

Date: Friday, 09/05/2008 1:45:19 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT ASSEMBLY		
Job Number	: 39152					
Estimate Number	: 10732					
P.O. Number	:			Part Number	: D23241	
This Issue	: 09/05/2008		S.O. No.	: D2324 REV. C		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 36749			Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	<u>JULY 08.5.09</u>			Due Date	: 05/06/2008	
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K			Qty:	20	Um: Each
	J/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	39152A	STOP				
		Comment: Sub-Component STOP D2324-3 B 36749A		<i>CB08/05/12</i>		
2.0	39152B	STRAP				
		Comment: Sub-Component STRAP D2324-5 B 37631		<i>CB08/05/12</i>		
3.0	AN312A	Bolt				
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s) Bolt M103947 (7x) M106605 33x		<i>CB08/05/12</i>		<i>CB08/05/12</i>
4.0	AN960JD10	Washer				
		Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s) Washer M107715		<i>CB08/05/12</i>		
5.0	MS21042L3	Nut				
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s) Nut M107644		<i>CB08/05/12</i>		<i>CB08/05/12</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2324. <i>8/08/05/12 20</i>
7.0	QC5 	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP <i>8/08/05/12 20</i>
8.0	POWDER COATING 	POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: <i>10:50</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>11:20</i> <i>FZ 08/05/13 20</i>
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT <i>8/08/05/14 420</i>
10.0	PACKAGING 1 	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST 203</i> <i>8/08/05/14 420</i>
11.0	QC21 	FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE <i>08/05/15 AF</i>
Job Completion 		<i>W 08/05/14</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

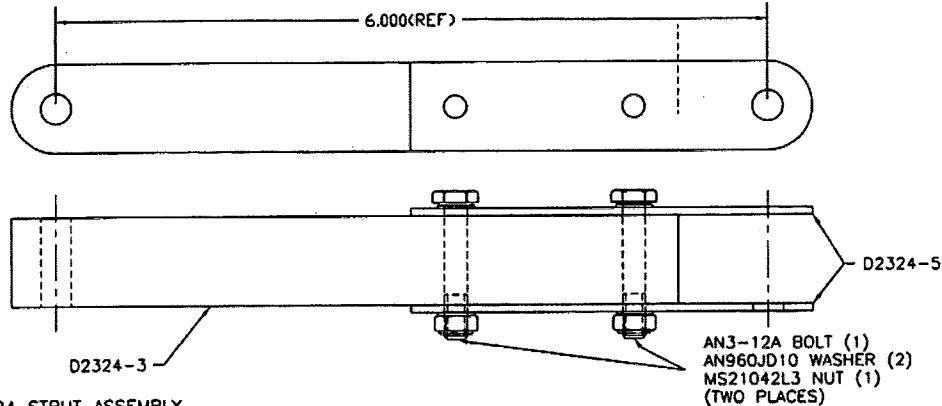
Part No: D2324-1 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: S Date: 08/05/15
 QA: N/C Closed: S Date: 08/05/15

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/13 B.0 C.5 6.0		During Powder coat inspection it was found that one strut has a loose scratch on it.	SJS Initial	Re Pull out scratch Re alodine affected area Alodine Start time: 2:25 Temp: 320° Finish time: 2:55 Re Powder coat AS ref QSI 005	08/05/13 SJS 08/05/13 08/05/13 08/05/13	Closed by SJS	SJS	08/05/13
			SJS Initial	FR AN3-12A M10x60 FR M10x60 FR M5x10x2 L3 M10x64 Remove and Replace Hardware	08/05/13 SJS 08/05/13	Closed by SJS	SJS	08/05/13

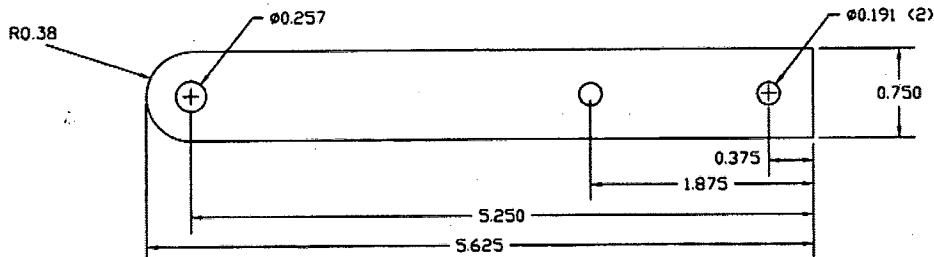
NOTE: Date & initial all entries

DART

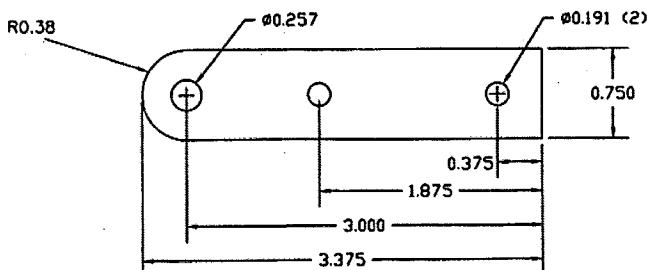
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14		TITLE STRUT	SCALE

RELEASED04.12.16 *[initials]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 39150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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